

IN THE CLAIMS

Please cancel claims 1-55, all of the claims in the application, as filed, as constituted by the verified translation of PCT/DE2003/003942. Please also cancel claims 1-54 as presented under Article 19 on June 24, 2004. Further please cancel claims 1-6 as submitted on December 15, 2004. Please add new claims 65-125 as follows.

Claims 1-64 (Cancelled)

65. (New) A printing blanket unit adapted for use with a printing blanket cylinder of a rotary printing press comprising:

- a dimensionally stable support plate including an exterior surface;

- an angled leading end leg on a leading end of said support plate;

- an angled trailing end leg on a trailing end of said support plate;

- a leading end fold on said support plate between said leading end leg and said exterior surface;

- a trailing end fold on said support plate between said trailing end leg and said exterior surface;

- a printing blanket on said exterior surface and having blanket leading and trailing ends with inside end surfaces situated adjacent said leading and trailing end folds; and

- a filler material at said leading and trailing blanket ends between said leading and trailing folds and said leading and trailing blanket inside end surfaces, said

filler material acting as a support element.

66. (New) The printing blanket unit of claim 65 wherein at least one of said printing blanket leading and trailing end surfaces protrudes beyond an associated one of said leading and trailing end folds and wherein said filler material supports said at least one protruding end surface.

67. (New) The printing blanket unit of claim 65 wherein a radius of said printing blanket unit in an installed portion on the printing blanket cylinder at an exterior surface of said printing blanket is equal at said leading and trailing blanket ends and intermediate said leading and trailing blanket ends.

68. (New) The printing blanket unit of claim 65 wherein in an installed portion of said printing blanket unit on the printing blanket cylinder, said leading end filler material and said trailing and filler material are unconnected with each other and with an opposite end of said printing blanket unit.

69. (New) The printing blanket unit of claim 68 wherein in said installed portion, said leading end filler material and said trailing end filler material are out of contact with each other.

70. (New) The printing blanket unit of claim 65 wherein in an installed portion of said printing blanket unit on the printing blanket cylinder, said leading end filler material and

said trailing end filler material, which are provided with lateral facing surfaces of a complementary shape, are adjacent each other.

71. (New) The printing blanket unit of claim 70 wherein said leading and trailing end filler materials are formed using one workpiece and are separated by cutting, said cutting forming said lateral facing surfaces.

72. (New) The printing blanket unit of claim 70 wherein a spacing distance between said lateral facing surfaces of said leading and trailing end filler material is between 0.2 mm and 0.8 mm.

73. (New) The printing blanket unit of claim 72 wherein said spacing distance is between 0.3 mm and .07 mm.

74. (New) The printing unit blanket of claim 73 wherein said spacing distance is between 0.4 mm and 0.6 mm.

75. (New) The printing unit blanket of claim 74 wherein said spacing distance is 0.5 mm.

76. (New) The printing unit blanket of claim 65 wherein said blanket leading and trailing ends are produced from a workpiece by cutting.

77. (New) The printing unit blanket of claim 65 wherein at least one of said leading and trailing end folds has a radius of between 0.3 mm and 0.7 mm.
78. (New) The printing blanket unit of claim 77 wherein said radius is 0.5 mm.
79. (New) The printing blanket unit of claim 65 wherein at least one of said leading and trailing end folds has a radius of between 0.6 mm. And 1.2 mm.
80. (New) The printing blanket unit of claim 79 wherein said radius is 0.8 mm.
81. (New) The printing blanket unit of claim 70 wherein a length of each of said filler materials, in a circumferential direction of the printing blanket cylinder is between 0.4 mm and 1.0 mm.
82. (New) The printing blanket unit of claim 70 wherein a length of each of said filler materials, in a circumferential direction of the printing blanket cylinder is between 0.1 mm to 1.3 mm.
83. (New) The printing blanket unit of claim 82 wherein said length is 0.7 mm.
84. (New) The printing blanket unit of claim 82 wherein said length is 0.5 mm.
85. (New) The printing blanket unit of claim 65 wherein said filler material extends in

a radial direction of the printing blanket cylinder past a vertical extension of said support plate exterior surface.

86. (New) The printing blanket unit of claim 65 wherein said printing blanket unit has at least one of said first and second ends of a first, end thickness and a central area located between said first and second ends of a second, central area thickness, said first thickness being greater than said second thickness whereby an exterior of said printing blanket unit at said end with said first end thickness extends in a radial direction of said printing blanket cylinder past a vertical exterior of said central area of said printing blanket unit.

87. (New) The printing blanket unit of claim 65 wherein said leading and trailing end folds are enclosed by said filler material.

88. (New) The printing blanket unit of claim 65 wherein said support plate is steel.

89. (New) The printing blanket unit of claim 65 wherein said printing blanket is multi-layered.

90. (New) The printing blanket of claim 65 wherein said filler material is one piece.

91. (New) The printing blanket of claim 65 wherein said printing blanket is a first material and said filler material is a second material different from said first material.

92. (New) The printing blanket unit of claim 65 wherein said printing blanket is a first material and said filler material is said first material.

93. (New) The printing blanket unit of claim 65 wherein said filler material is secured to said printing blanket prior to the mounting of said printing blanket on said support plate.

94. (New) The printing blanket unit of claim 65 wherein the printing blanket cylinder is in contact with a forme cylinder in the rotary printing press.

95. (New) The printing blanket unit of claim 94 further including at least one printing blanket on said forme cylinder.

96. (New) The printing blanket unit of claim 95 wherein said forme cylinder has a circumferential surface with at least one surface interruption.

97. (New) The printing blanket unit of claim 95 wherein said filler material contacts said printing blanket.

98. (New) The printing blanket unit of claim 65 wherein said printing blanket is situated on top of said filler material.

99. (New) A method for providing a printing blanket unit usable with a printing

blanket cylinder of a rotary printing press, including:

- providing a dimensionally stable support plate having an exterior surface;

- providing leading and trailing ends of said support plate;

- providing an angled plate leg on each of said leading and trailing ends of said support plate;

- forming a fold at a juncture of said exterior surface and each of said leading and trailing end angled plate legs;

- providing a printing blanket having leading and trailing printing blanket inside ends;

- providing a processing cylinder having a shape corresponding to a shape of the printing blanket cylinder;

- fastening said support plate on said processing cylinder using said angled plate end legs;

- securing said printing blanket on said support plate with said leading and trailing printing blanket inside ends protruding beyond said folds of said associated one of said leading and trailing end angled plate legs;

- defining a gap between said angled plate end legs;

- filling said gap with a support material; and

- cutting through said support material and forming leading and trailing end support elements using said support material.

100. (New) The method of claim 99 further including initially providing said printing blanket having a flat shape prior to attaching said printing blanket to said support plate,

defining a printing blanket gap between said printing blanket leading and trailing inside ends, placing a sealing material in said printing blanket end gap and cutting said sealing material for removing said printing blanket unit from said processing cylinder.

101. (New) The method of claim 100 further including processing said cut sealing material and forming cylindrical circumferential surfaces of said sealing material.

102. (New) The method of claim 100 further including cutting said sealing material and said support material simultaneously.

103. (New) The method of claim 99 further including providing at least one sub-structure layer and applying said at least one sub-structure layer to said support plate and forming said support material.

104. (New) The method of claim 103 further including applying said sub-structure layer and said support material to said support plate simultaneously.

105. (New) A method for producing a printing blanket unit usable with a printing blanket cylinder of a rotary printing press including:

providing a dimensionally stable support plate having an exterior surface;

folding at least one end of said support plate along a fold;

applying a filler material to said at least one end of said support plate at

said fold;

providing a printing blanket having first and second ends;
applying said printing blanket to said support plate; and
at least partially covering said filler material with said printing blanket
applied to said support plate, with said filler material being located at least at one end of
said printing blanket.

106. (New) The method of claim 105 further including providing said filler material at
both of said first and second ends of said printing blanket.

107. (New) The printing blanket of claim 106 further including providing said filler
material at both of said first and second ends of said printing blanket unconnected from
each other.

108. (New) The method of claim 105 further including a production device and
providing said filler material to said production device.

109. (New) The method of claim 105 further including providing said filler material in a
flowable state.

110. (New) The method of claim 105 further including deforming said filler material.

111. (New) The method of claim 105 further including vulcanizing said printing
blanket.

112. (New) The method of claim 105 further including providing a separate filler material to each of first and second ends of said printing blanket unit.

113. (New) The method of claim 105 further including shaping an exterior surface of said filler material.

114. (New) A method for providing a printing blanket unit including:

providing a dimensionally stable support plate having first and second plate ends;

folding said first and second plate ends along folds;

providing a printing blanket having printing blanket leading and trailing ends;

securing said printing blanket to said support plate; and

applying a filler material to said ends of said support plate and said printing blanket, said filler material forming a support element.

115. (New) The method of claim 114 further including releasing said printing blanket from said support plate before folding said support plate.

116. (New) The method of claim 114 further including making said support plate of metal.

117. (New) The method of claim 114 further including providing said printing blanket

being multi-layered.

118. (New) The method of claim 114 further including providing said filler material as one piece.

119. (New) The method of claim 114 further including providing said filler material and said printing blanket as different materials.

120. (New) The method of claim 114 further including providing said filler material and said printing blanket as the same material.

121. (New) The method of claim 114 further including placing said filler material on said printing blanket unit and then mounting said printing blanket unit on a printing blanket cylinder.

122. (New) The method of claim 114 further including providing a printing blanket cylinder, positioning said printing blanket unit on said printing blanket cylinder, providing a forme cylinder and contacting said forme cylinder with said printing blanket cylinder.

123. (New) The method of claim 122 further including providing at least one printing plate on said forme cylinder.

124. (New) The method of claim 123 further including providing at least one printing

plate receiving groove on a circumferential surface of said forme cylinder.

125. (New) The method of claim 122 further including using said filler material for contacting and supporting said printing plate.